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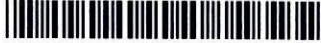
D4653-7
Job Sheet 169894



Part No: D4653-7

Job Qty: 30 ea

Part Name: Fitting, Large



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/16/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		1/15/18	0.00	0.00	Start Up Machining-3		
100	Doosan	30 pcs		1/16/18	0.26	5.55	Doosan		
120	QC	30 pcs		1/16/18	0.00	0.00	QC8		
130	Packaging	30 pcs		1/16/18	0.00	0.00	Packaging3-2		
140	QC21-SA	30 Ea		1/16/18	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.000	5	48	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Large Fitting	1.380Inches ± 0.030	1.380 1.410 1.350		
2	Large Fitting	0.250Inches ± 0.010	0.250 0.260 0.240		
3	Large Fitting	45.000Degrees ± 0.500	45 45.500 44.500	Angle	
4	Large Fitting	0.0940inches ± 0.0300	0.094 0.1240 0.0640	Radius	
5	Large Fitting	2.120Inches ± 0.030	2.120 2.150 2.090		
6	Large Fitting	0.825Inches ± 0.010	0.825 0.835 0.815	Diameter	
7	Large Fitting	0.547Inches ± 0.010	0.546 0.557 0.537	Diameter	
8	Large Fitting	0.0990inches ± 0.0100	0.097 0.1090 0.0890		
9	Large Fitting	0.745Inches + 0.000 - 0.005	0.742 0.745 0.740	Diameter	

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Fitting, Large

PART NO: D4653-7
Original Serial #: S032599
Revision:
Operation: Start up Operation 01/16/18
Change No: Job No: 169894

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
			QTY Effective :			MRB (QSI042) Approval	
			Disposition			Completed By	
						Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval		

FAULT CATEGORY		
☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Countersink	☐ Off-set	☐ Drawing
☐ Cut Too Short	☐ Misabeled	☐ Finish
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence